

Date: Thursday, 6/29/2006 8:28:05 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 27764	
Estimate Number : 10534	
P.O. Number : N/A	Part Number : D2574
This Issue : 6/29/2006 S.O. No. : N/A	Drawing Number : D2574 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 27598	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 7/15/2006 Qty: 16 Um: Each
Checked & Approved By : <u>06 06 29</u>	
Comment : Est Rev: I As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2574
Ensure that grain is along 5.00" length
Batch No: 13 23940 x 16 EN / J.G.

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No 27764 Double check by: me

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

06/07/07

J.G. / En 16

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2573 & D2574

06/07/07

J.G. / En 16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/07/07

J.G. / En 16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/29/2006 8:28:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 27764

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ML

06/07/10

16

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD

06/07/11

16

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

* Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SE

06/07/12

(16)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Rec'd 7/13

(16)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *352*

Rec'd 7/13

(16)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.14

Job Completion



W 06.07.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries.

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 27764
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

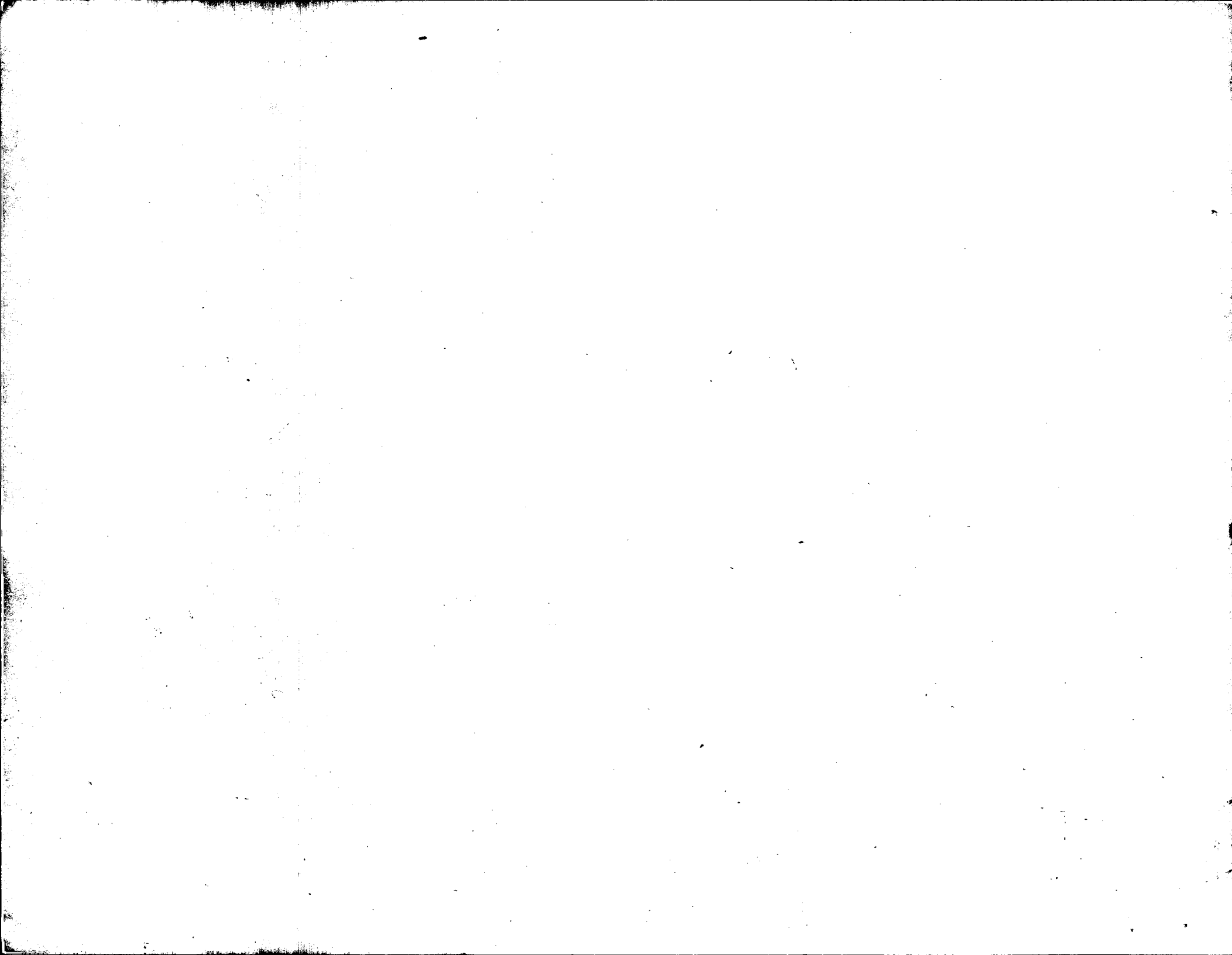
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.748	1.746	1.746		
C	3.495	3.505		3.500	3.499	3.497	3.500		
D	1.745	1.755		1.749	1.748	1.746	1.746		
E	7.990	8.010		8.003	8.002	8.001	8.000		
F	0.490	0.510		0.501	0.500	0.499	0.495		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.499	0.499	0.493	0.496		
J	1.174	1.184		1.179	1.177	1.175	1.175		
K	0.558	0.578		0.569	0.568	0.562	0.561		
L	1.174	1.184		1.179	1.177	1.175	1.175		
M	1.365	1.375		1.371	1.370	1.368	1.366		
N	2.495	2.505		2.501	2.500	2.497	2.499		
O	4.119	4.129		4.122	4.121	4.119	4.120		
P	0.115	0.135		0.130	0.129	0.124	0.122		
Q	0.115	0.135		0.125	0.124	0.125	0.135		
R	0.240	0.260		0.244	0.249	0.251	0.250		
S	0.115	0.135		0.122	0.123	0.120	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.231	3.230	3.230		
V	0.230	0.250		0.241	0.239	0.241	0.236		
W	0.115	0.135		0.127	0.126	0.126	0.125		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.761	0.761	0.765	0.765		
Z	0.352	0.372		0.362	0.362	0.365	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.628	0.621	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.250	0.247	0.244		
AE	1.500	1.520		1.511	1.512	1.513	1.513		
AF	0.115	0.135		0.128	0.127	0.135	0.135		
AG	0.240	0.280		0.250	0.251	0.260	0.260		
AH	0.240	0.260		0.251	0.251	0.244	0.245		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	J.G/Er
Date:	06/07/10

Audited by:	JML
Date:	06/07/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



DART AEROSPACE LTD	Work Order:	27764
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.746	1.746	1.747	1.746		
C	3.495	3.505		3.496	3.500	3.498	3.499		
D	1.745	1.755		1.746	1.746	1.747	1.746		
E	7.990	8.010		8.000	8.000	8.000	8.001		
F	0.490	0.510		0.493	0.499	0.495	0.491		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.495	0.501	0.498	0.499		
J	1.174	1.184		1.178	1.175	1.177	1.176		
K	0.558	0.578		0.561	0.563	0.563	0.564		
L	1.174	1.184		1.178	1.175	1.177	1.176		
M	1.365	1.375		1.368	1.365	1.369	1.368		
N	2.495	2.505		2.495	2.497	2.498	2.497		
O	4.119	4.129		4.119	4.119	4.120	4.119		
P	0.115	0.135		0.123	0.124	0.125	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.252	0.253	0.253		
S	0.115	0.135		0.124	0.121	0.123	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.236	0.238	0.241	0.240		
W	0.115	0.135		0.124	0.126	0.122	0.120		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.361	0.367	0.365	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.626	0.622	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.246	0.245	0.245		
AE	1.500	1.520		1.509	1.510	1.511	1.511		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.248	0.249	0.250		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	En
Date:	06/07/05

Audited by:	JML
Date:	06/07/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27764
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

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Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.745	1.747	1.747	1.747		
C	3.495	3.505		3.497	3.498	3.499	3.499		
D	1.745	1.755		1.745	1.747	1.748	1.747		
E	7.990	8.010		8.001	8.000	8.001	7.998		
F	0.490	0.510		0.498	0.497	0.494	0.500		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.499	0.499	0.499	0.499		
J	1.174	1.184		1.174	1.179	1.180	1.180		
K	0.558	0.578		0.565	0.564	0.568	0.567		
L	1.174	1.184		1.174	1.179	1.180	1.180		
M	1.365	1.375		1.370	1.371	1.372	1.374		
N	2.495	2.505		2.498	2.497	2.498	2.497		
O	4.119	4.129		4.122	4.121	4.122	4.120		
P	0.115	0.135		0.125	0.124	0.124	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.254	0.252	0.254		
S	0.115	0.135		0.125	0.124	0.123	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.241	0.242	0.243		
W	0.115	0.135		0.126	0.127	0.126	0.127		
X	0.307	0.312		0.316	0.316	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.361	0.362	0.365	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.620	0.621	0.626	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.244	0.244	0.243		
AE	1.500	1.520		1.511	1.509	1.509	1.508		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.251	0.252	0.252		
AI	2.000	2.020		2.014	2.014	2.014	2.014		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP / J.G.
Date:	06/07/06

Audited by:	ML
Date:	06/07/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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DART AEROSPACE LTD	Work Order: 27764
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

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C	3.495	3.505		3.498	3.497	3.498	3.498		
D	1.745	1.755		1.748	1.748	1.747	1.747		
E	7.990	8.010		8.000	8.000	7.999	7.999		
F	0.490	0.510		0.501	0.499	0.499	0.501		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.500	0.501	0.499	0.497		
J	1.174	1.184		1.180	1.180	1.179	1.180		
K	0.558	0.578		0.569	0.569	0.568	0.569		
L	1.174	1.184		1.180	1.179	1.179	1.180		
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R	0.240	0.260		0.250	0.257	0.251	0.252		
S	0.115	0.135		0.121	0.120	0.122	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.231	3.230	3.231		
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W	0.115	0.135		0.124	0.123	0.123	0.124		
X	0.307	0.312		0.310	0.311	0.310	0.309		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.364	0.365	0.364	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.625	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.249	0.248	0.247		
AE	1.500	1.520		1.508	1.509	1.508	1.512		
AF	0.115	0.135		0.130	0.129	0.128	0.127		
AG	0.240	0.280		0.270	0.261	0.262	0.261		
AH	0.240	0.260		0.261	0.262	0.269	0.263		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

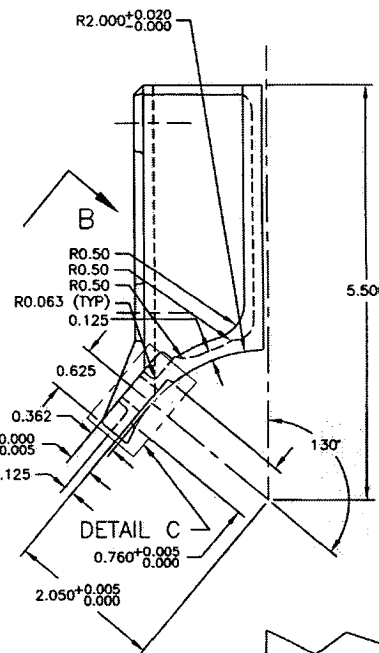
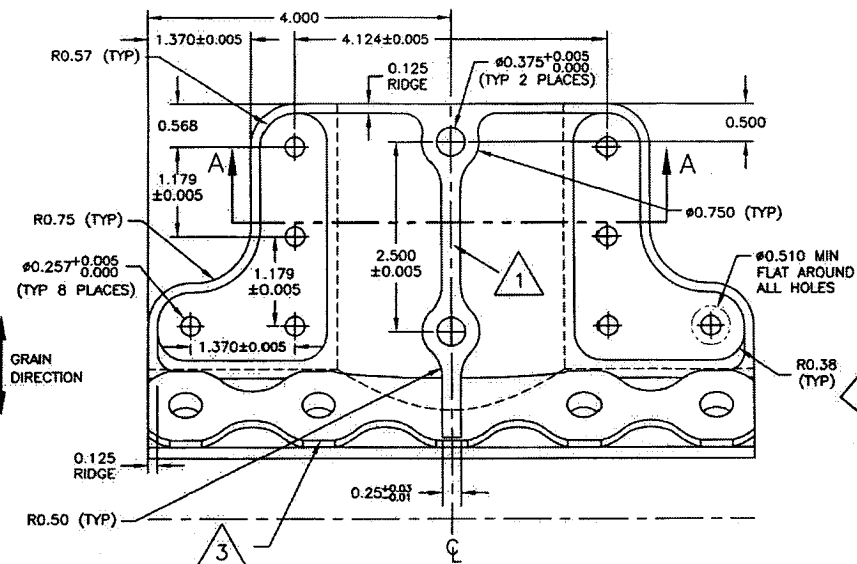
Measured by: S.G
Date: 06/07/07

Audited by: me
Date: 06/07/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
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RELEASED

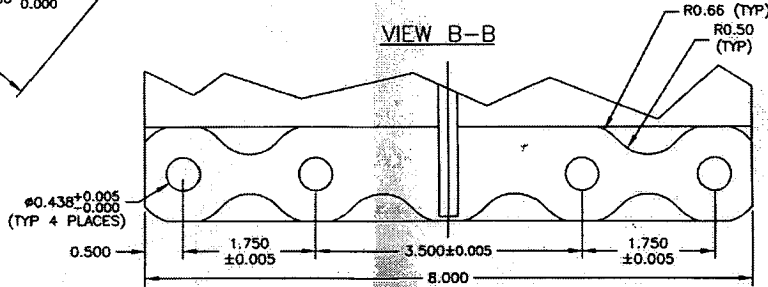
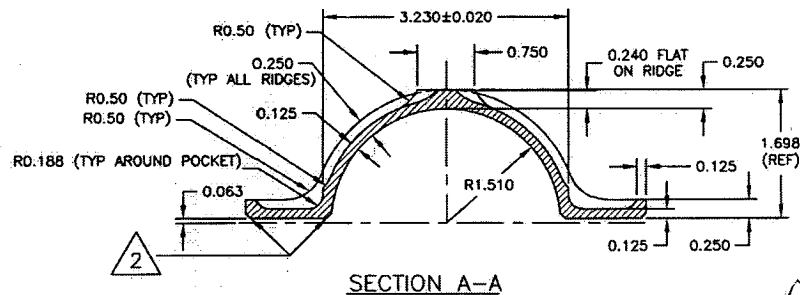
05.12.06



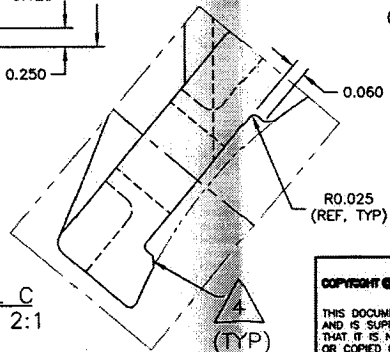
NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



DETAIL C
SCALE 2:1



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCPOR. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED		APPROVED
DATE	05.07.13	TITLE
		INNER AFT SADDLE

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DART AEROSPACE LTD.
WARRICK, ONTARIO, CANADA

REV. E
SHEET 1 OF 1
SCALE
2:1

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WITHOUT NOTICE
WORK ORDER
NO. 27764

